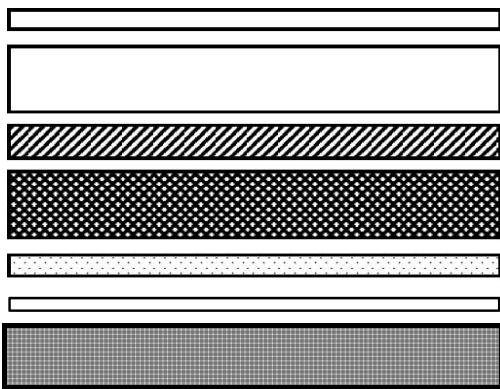


TECHNICAL DATA FOR THERMOFOIL FILMS AND VEN4MA FR SHEET

SpecTrim Thermofoil Film is a two ply calendared rigid PVC film that has been printed with a decorative pattern. The composite is embossed with a variety of available patterns from SpecTrim Building Products. The composite includes an abrasion resistant topcoat and an adhesion promoting primer. Although the composite is suitable for all applications, it is best fitted for membrane press, flat laminating, wrapping, and vacuum forming processes. Venforma adheres decorative film face to an impact resistant backing.



Abrasion Resistant Top Coat

Overlay

Print layer

Base Film(s)

Adhesion Promoting Primer

Adhesive Layer (no VOC / all solids) Ven4maFR only

Acrylic/PVC Alloy Sheet .028" thick- Ven4maFR only

Film Width: Film pattern widths of 49"to 57".

Ven4ma Width: Maximum width 48". Film pattern #03, 08, and 16 maximum width is 47 1/2".

Film Gauge: 12 and 16 mil

Color: Is matched visually against a full width print repeat of the print standard. In the case of stock colors or existing colors, the Q. A. Manager shall maintain and provide, when necessary, samples of an existing standard.

TYPICAL PROPERTIES

Hoffman Scratch	1600-1700 g
Gardner Ball Drop	3000+mm
Tensile Strength	6100 psi
Notched Izod Impact	18 ft-lb/in
Burnish	8; wipes
Coating Adhesion	1
Taber Abrasion	30-32
Rockwell Hardness	94

Burnish Rating:

10 = no burnish
 9 = slight burnish
 8 = moderate burnish
 7 = severe burnish; not removed by alcohol wipe

Rockwell R scale



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TECHNICAL DATA FOR THERMOFOIL FILMS AND VEN4MA FR SHEET

CHEMICAL RESISTANCE

SOLVENT

Solvent Type	Results
MEK	3
Toluene	2
Acetone	3
Alcohol	0

Rating Legend

- 0 = No Effect
- 1 = Slight Effect
- 2 = Moderate Effect
- 3 = Film bubbling/severe effect

NEMA STAIN RESISTANCE TEST LD 3.4 1995

Test Material	0	1	2	3	4	SCORE	STAIN
Distilled Water						0	N
Ethyl Alcohol and Water 50/50						0	N
Acetone						0	N
Household Ammonia						0	N
Citric Acid 10%						0	N
Vegetable Cooking Oil						0	N
Coffee						0	N
Tea						0	N
Tomato Catsup						0	N
Mustard						0	N
Iodine 10%						0	N
Supermarket Stamp Ink	1	1				2	N
#2 Pencil	1					1	N
Wax Crayon	1	1				2	N
Shoe Polish	1	1				2	N
						Total	7

Cleaning Steps (See NEMA LD3 1995 For Full Description)

- 0 = Removed with water
- 1 = 20 cycles spray cleaner on sponge
- 2 = 20 cycles baking soda + spray cleaner on brush
- 3 = Nail polish remover + cotton ball
- 4 = Bleach + cotton ball
- 5 = Not removed. Describe stain as Moderate (M) or Severe (S)

Stain Resistance

- N = No Effect
- M = Moderate Effect, difficult to perceive stain
- S = Severe Effect easily perceived stain, or damage surface



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TECHNICAL DATA FOR THERMOFOIL FILMS AND VEN4MA FR SHEET

KCMA CHEMICAL RESISTANCE 9.3

TEST MATERIAL	INITIAL	14 DAY
Vinegar	No Effect	
Lemon Juice	No Effect	
Orange Juice	No Effect	
Grape Juice	No Effect	
Tomato Catsup	No Effect	
Coffee	No Effect	
Olive Oil	No Effect	
Alcohol 100 proof	No Effect	
Detergent Solution	No Effect	
Mustard	Moderate	No Effect

Rating Legend

No Effect = No discoloration or stain after cleaning with water.

Moderate Effect = Slight stain or discoloration could be seen after cleaning.

Severe Effect = Definite stain after cleaning, remaining after 14 days.

Flame Resistance

SpecTrim PVC film and Ven4maFR products have been tested to ASTM E-84 and qualify as Class I
Flame spread index is less than 25
Smoke development is less than 450